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DART AEROSPACE LTD	Work Order:	20737
Description: Bracket	Part Number:	D3146-1
Dwg: D3146 Rev. A	Qty:	10
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	04.04.29	10
2	MV	Cut blanks: 4.500" x 1.250" x 3.100" long Bar Material: 6061-T6/T651 (QQ-A-200/8) 1.250" thick (M6061T6B1.250x04.500) Identify for D3146-1 Batch: 3514962	CD	04/05/27	10
3	MV	Machine as per Folio FA419 and Dwg D3146 Identify as D3146-1	SP	04/05/31	10
4	QC2	Inspect parts as they come off the CNC machine	SP	04/05/31	10
5	QC8	Second check	EC	04/05/31	10
6	MV	Deburr and Tumble	SP	04/06/01	10
7	FP	Chemical Conversion Coat as per QSI 005 4.1	ML	04.06.03	10
8	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	2	04.06.17	10
9	QC3	Inspect Powder Coat	MM	04.06.17	10
10	QC5	Inspect work to Step 9	VB	04.06.17	10
11	ST	Identify and Stock in Spacedoor Cell	CAP	04/06/17	10
12	AC	Cost / part 47.66	SAC	04-06-18	10
13	DC	Close W/O 59.58 Inspect Level 21	KJ	04.06.21	10

Rev	Date	Change	Revised By	Approved
A	04.04.28	New issue	KJ/JLM	

RELEASED

04.04.29



Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NOTE: Date & Initial all entries
H:\Admin-QA\ISO forms\wopcB.doc

DART AEROSPACE LTD		Work Order:	20737
Description: Bracket		Part Number:	D3146-1
Inspection Dwg: D3146	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.000	+/-0.010	2.995	✓			
2.000	+/-0.010	2.004	✓			
0.230	+/-0.010	.227	✓			
0.425	+/-0.010	.423	✓			
3.420	+/-0.010	3.417	✓			
2.535	+/-0.010	2.532	✓			
0.221	+/-0.010	.222	✓			
0.391	+/-0.010	.389	✓			
0.221	+/-0.010	.222	✓			
0.850	+/-0.010	.844	✓			
R0.350	+/-0.010	.350	✓			
0.850	+/-0.010	.845	✓			
0.221	+/-0.010	.221	✓			
0.491	+/-0.010	.492	✓			
0.125	+/-0.010	.125/.115	✓	✓		Bottom not equal on all corners.
1.025	+/-0.010	1.030	✓			
R0.375	+/-0.010	.375	✓			
28°	+/-0.1°	27.5°	✓			TURN LOGO & P/N 180° AT SHOW IN DWG D3146-Rev. A
0.276	+/-0.010	.269	✓			
0.925	+/-0.010	.921	✓			
R0.125	+/-0.010	.125	✓			
4.345	+/-0.010	3.340	✓			
0.125	+/-0.010	.125	✓			
68°	+/-0.1°	9.30	✓			
R0.125	+/-0.010	.125	✓			
Grain Direction	MATERIAL FINISH					

PRELIMINARY ISSUE

Measured by:	Audited by:
Date: 04.05.31	Date: 04.05.31

Prototype Approval:	RF
Date:	04.05.31

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

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NOTES:

1) MATERIAL NOT TO BE USED
2) FINISH POWDER COAT (100%)
3) TOLERANCES ARE PER DAY
4) ALL DIMENSIONS ARE IN INCHES
5) ALL SHARP EDGES
6) PART PIN IN

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DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3146	REV. A
DATE 02.04.25		TITLE BRACKET	SHEET 1 OF 1
A		02.04.25	SCALE 1:2
NEW ISSUE			

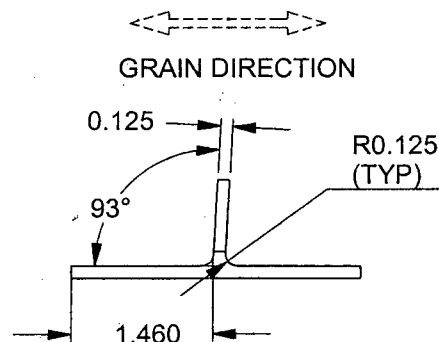
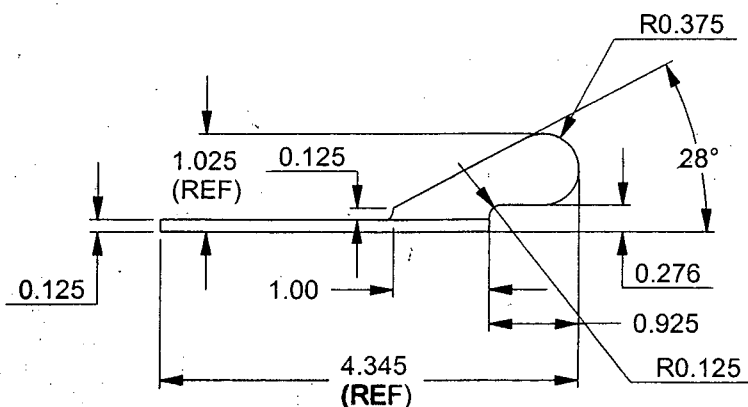
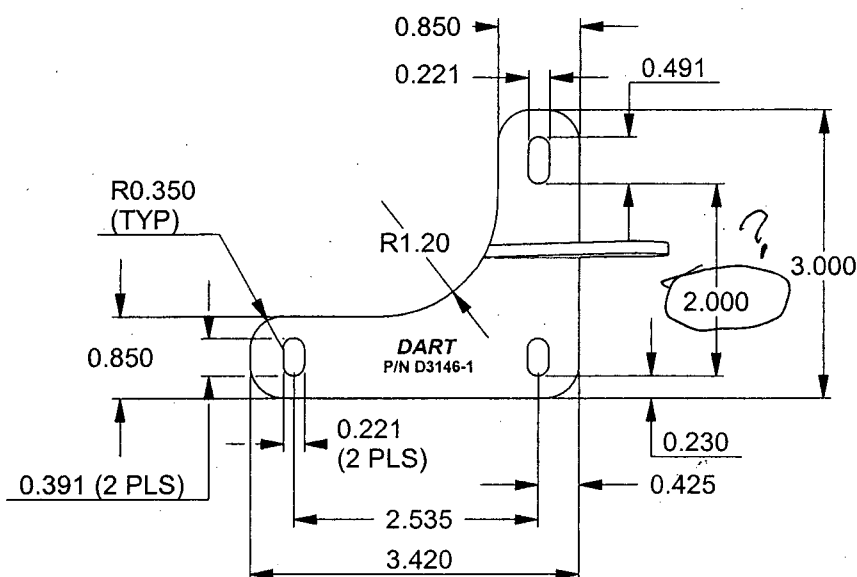
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02.05.27 #

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WORK ORDER
NO. 20737



D3146-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-27
(D3146-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-28)

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

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1) ENGEL, DE DAVIS, MIMI
2) LEE, KAY, ATT, SHARBY, ERIC
3) LEE, DIMITRI, GIGI, MIMI
4) LEE, DIMITRI, GIGI, MIMI
5) LEE, DIMITRI, GIGI, MIMI
6) LEE, DIMITRI, GIGI, MIMI
7) LEE, DIMITRI, GIGI, MIMI
8) LEE, DIMITRI, GIGI, MIMI
9) LEE, DIMITRI, GIGI, MIMI
10) LEE, DIMITRI, GIGI, MIMI

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 20, 2004
02:46 pm

Work Order No : 0020737
Project Name : D3146-1
Project For : WK420
Work Order Type : Main
Main WO Number :
House Part Number : D3146-1
Description : Hinge Bracket
Manufactured : No
Amount Req'd : ~~810~~
Amount Done : 0
Start Date : 04-20-04
Est Finish Date : 05-10-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00